

his wk 3/03

Date: Monday, 3/5/2007 4:23:15 PM
 L: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 31022	
Estimate Number : 12769	
P.O. Number : <i>N/A</i>	Part Number : 41232 200 005 003
This Issue : 3/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : 41232-200-005 REV IR
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : IR
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : _____	Due Date : 3/30/2007 Qty: 40 Um: Each
Checked & Approved By : <i>07.03.06</i>	
Comment : Est Rev:A New Issue 07-03-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR0500	Delrin Round Bar .50"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)
 Delrin Round Bar .50"
 Batch: *M102820*

MS 07/03/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA680 & DWG 41232-200-005,
 FOLIO REV: *new prog MS*
 DWG REV: *IR*

2-DEBURR AS REQUIRED

MS 07/03/27

43

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/03/27

43

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/03/27

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

EC 7/3/28

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/03/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/5/2007 4:23:15 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 31022

Part Number: 41232 200 005 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



43

Comment: FINAL INSPECTION/W/O RELEASE

07/03/09

Job Completion



u 07-03-29

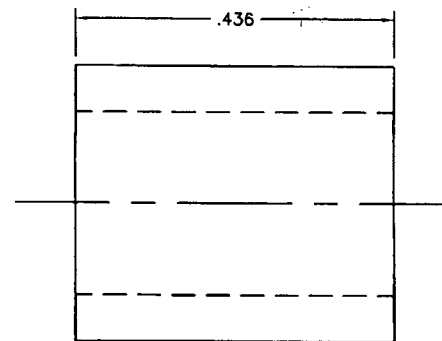
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

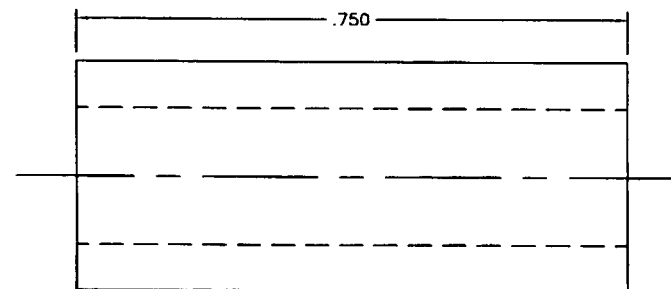
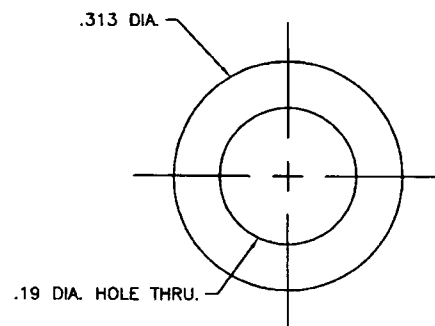
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



-001 SPACER



-003 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31022

					-003	SPACER	.313' x .750	ACETRON N.S.	CADILLAC PLASTICS, FORT WORTH, TX.		
					-001	SPACER	.375' x .436	ACETRON N.S.	CADILLAC PLASTICS, FORT WORTH, TX.		
					PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	
NO. REQ'D PER ASSY					LIST OF MATERIAL						
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						XX.±.03	CHECK D. MURPHY	5/29/02	SPACER		
						XXX.±.010	STRESS				
						ANGLES ±.1/2°	PROD. ENGR.		DWG. SIZE C	SCALE 1 : .125	
							HEAT TREAT			DWG. NO.	REV.
							FRESH	Era Aviation, Inc.		41232-200-005	IR

DART AEROSPACE LTD		Work Order:	31022
Description: Spacer		Part Number:	4132-200-005-003
Inspection Dwg:	Rev: IR	Page 1 of 1	

41232-200-005-003

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi .19$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.191	✓			
B $\phi .313$	$\begin{matrix} +.006 \\ -.001 \end{matrix}$.315	✓			
C .750	$\pm .010$.752	✓			
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: MS	Audited by: J.L	Prototype Approval:	N/A
Date: 07/03/27	Date: 07/03/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	